

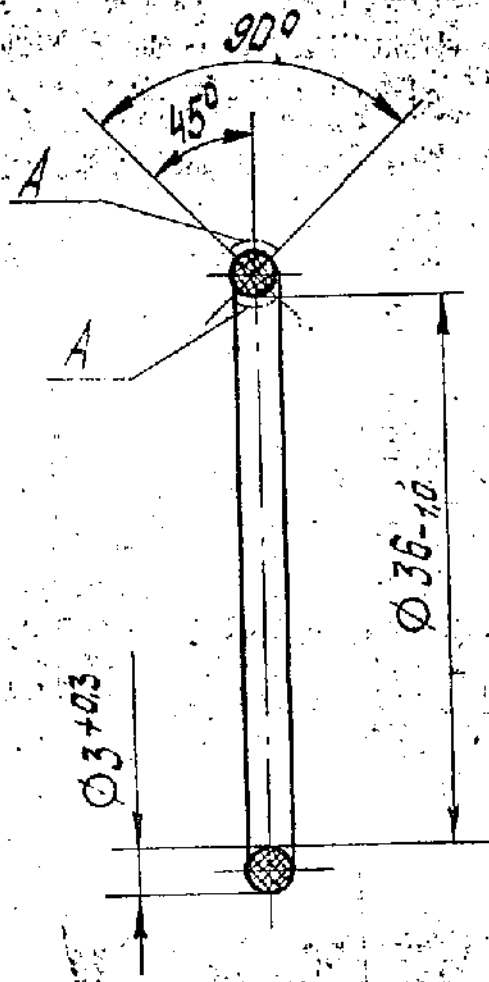
04.00.033



80384-74

8

24





1. It is permissible to use rubber HO-68-1, TY 38-005.1166-73.
2. Surface roughness and ring dimensions are ensured by the production process.
3. Surfaces A are working surfaces.
4. Other technical requirements are according to Group B, TY 38-005-838-70. Mark the appropriate stamp on the tag for the lot.
5. Mark the appropriate stamp on the tag for the lot (A).
6. Sulphur inclusions and sulphur stains and traces on the surface are not allowed.

Восстановлен с подлинного н/т  
 Верно: М.И. Кузьмина  
 25.09.84

ТО ВЗОНУНБ.НО  
 ЧИВ.НО ВЗОН  
 ПРОВОДИТ

25.09.84

APPROVED	 M VASU	04-00-033	28 D 2177	
CHECKED		RING	WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)			0.001	2:1
			SHT	SHTS 1
		RUBBER STOCK 14K-10, TY 38-005.1166-73		

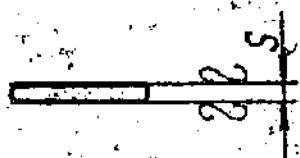
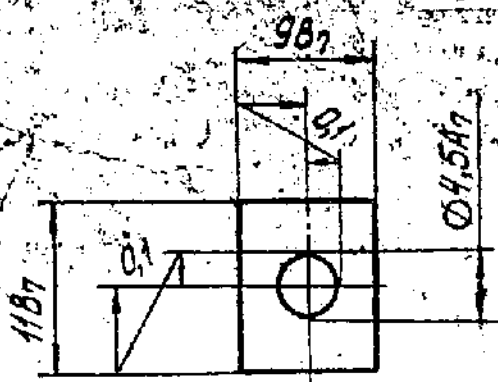
ВОССТАНОВИТЕЛЬНЫЙ ПОДШИПНИК

921201 04.00.105  
107,126



105 107,126

V3 unless otherwise specified



Table

Designation	Material	Mass	S
04.00.105	Band $\frac{12 \times 18 \text{H10T-M-0,1}}{\text{ГОСТ 4986-79}}$	0.00006	0.1
04.00.106	Band $\frac{12 \times 18 \text{H10T-M-0,15}}{\text{ГОСТ 4986-79}}$	0.00009	0.15
04.00.107	Band $\frac{12 \times 18 \text{H10T-M-0,2}}{\text{ГОСТ 4986-79}}$	0.0012	0.2
04.00.126	Band $\frac{12 \times 18 \text{H10T-M-0,4}}{\text{ГОСТ 4986-79}}$	0.0024	0.4

1. All dimensions (except for thickness) are ensured by the production process.
2. Remove burrs.
3. Mark the appropriate stamp on the tag for the lot (A).

Восстановлен с подлинника  
Верно: 105 107,126

7 13001.008.10 105 107,126

APPROVED	<i>[Signature]</i> R VASU	04.00. $\frac{105}{107,126}$	32/0 2177	
CHECKED	<i>[Signature]</i>	GASKET	WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)			(SEE THE TABLE)	2:1
		SHT	SHTS	

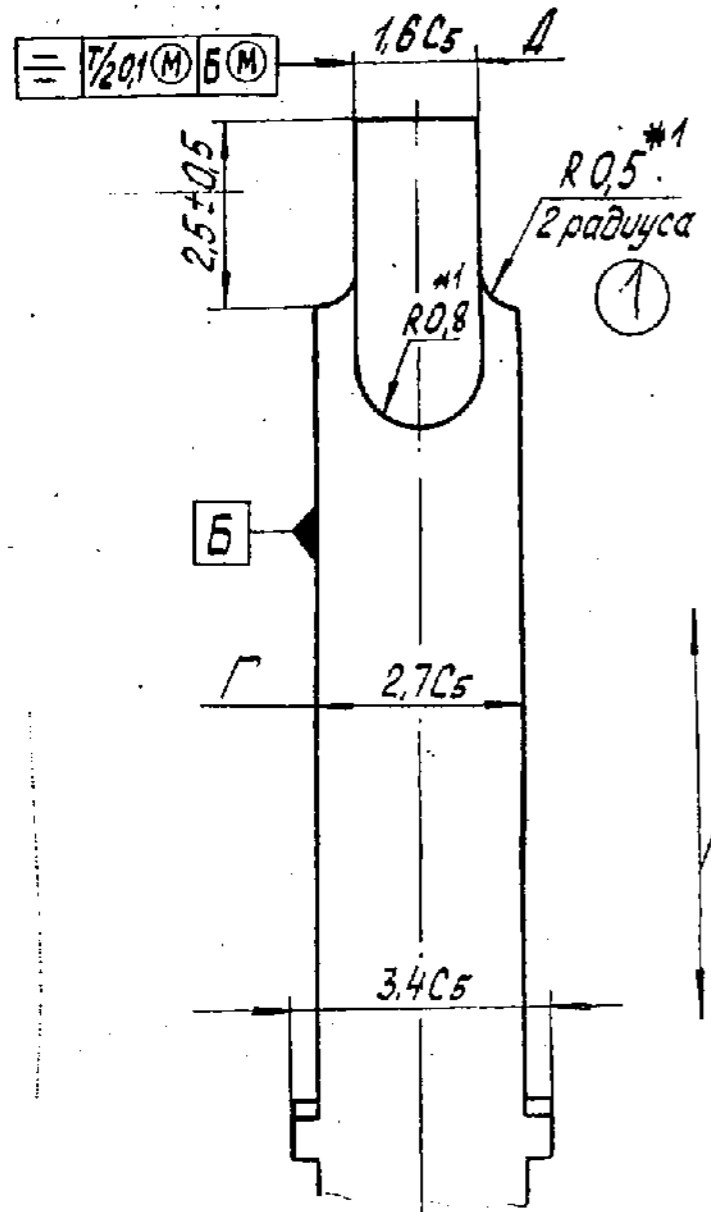


Rz 80 ✓ (✓) 23

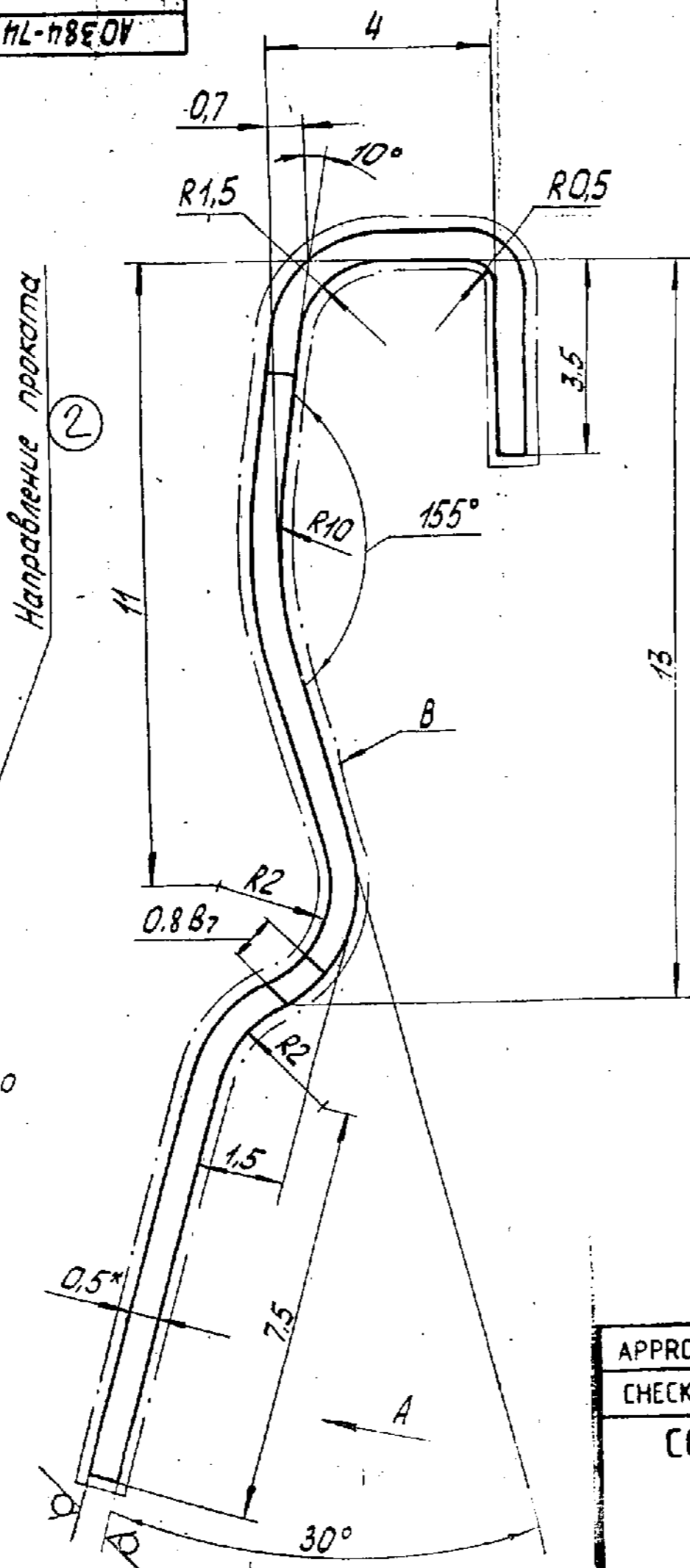
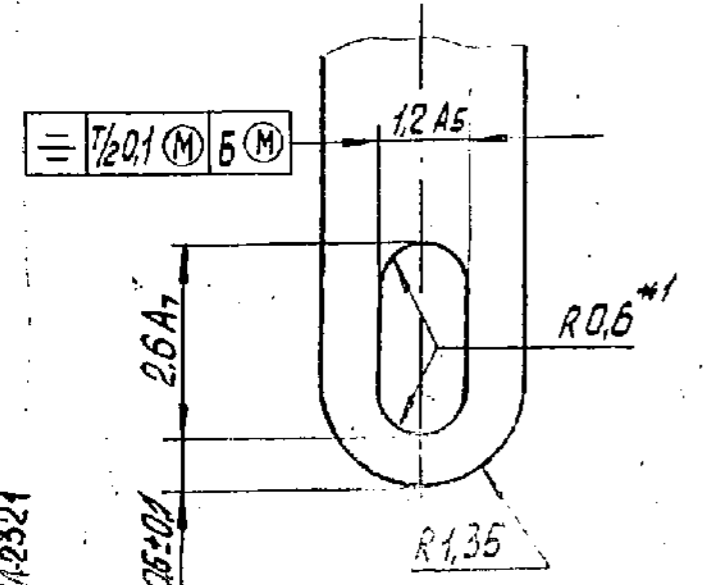
9M111.04.00.032 HL-n8E0V

Перв. примен. 9M111.04.00.120  
Сред. №

Изм. № 14073  
Подп. и дата 23.01.84  
Изм. № 14073  
Подп. и дата 23.01.84



3 Вид А повернуто



- ① 2 radii
- ② Direction of rolling
- ③ View A (revolved)
- ④ 1. Substitute material: band БрБ2-М-0,5, ТУ 48-21-265-82.  
2. HV 280 to 380.  
3. Deviation along contour is  $B \pm 0.25$  mm.  
4. Dimensions marked with an asterisk (\*) are given for reference.  
5. Dimensions marked with (\*1) are ensured by the tools.  
6. Dimensions  $\Gamma$  and  $\Pi$  may be increased up to 0.1 mm in the bending points.  
7. Coating: Cp15 (silver)  $F = 0.0169$  dm<sup>2</sup>.  
8. Mark the appropriate stamps on the tag for the lot (K, M).  
9. After heat treatment check the part by visual inspection for absence of cracks with the help of an optical device with 5X magnification.

APPROVED	<i>M VASU</i>	9M111.04.00.032 27/0 2177	
CHECKED	<i>M. Babitskaya</i>	CONTACT	WEIGHT
CONTROLLERATE OF INSPECTION (ICV)			0.00034
		BAND БрБ2-М-0.5, ГОСТ 1789-70	

Формы	Зона	Поз.	DESIGNATION	DESCRIPTION	Qty	Примечание
			Обозначение	Наименование		
				DOCUMENTATION		50
				Документация		
		A2	10ПР1-9П135.000СБ ✓	ASSEMBLY DRAWING		
				Сборочный чертеж		
		A3	10ПР1-9П135.000BC ✓	SPECIFICATIONS LIST		
				Ведомость спецификаций		
				ASSEMBLY UNITS		
				Сборочные единицы		
		A4	1 10ПР1-9П135.020 ✓	Розетка RECEPTACLE	1	
		A4	2 10ПР1-9П135.030 ✓	Заглушка PLUG	1	
				Детали PARTS		
		A4	4 10ПР1-9П135.004 ✓	Гайка NUT	1	
		A4	5 10ПР1-9П135.005 ✓	Шайба WASHER	2	
		A4	6 10ПР1-9П135.006 ✓	Прокладка GASKET	1	
		A4	7 9М111.04.00.105 ✓	Прокладка GASKET	6	
		A4	9 9М111.04.00.106 ✓	Прокладка GASKET	2	
		A4	10 9М111.04.00.107 ✓	Прокладка GASKET	6	
		A3	11 9М111.04.00.125 ✓	Защелка задний REAR HOOD	1	

Н.Колтун  
 2017.09.12.01.81  
 Форма  
 10ПР1-9П135.000


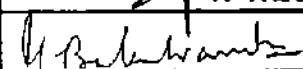
APPROVED	<i>M. VASU</i>	10ПР1-9П135.000	D 2177/58
CHECKED	<i>V. Bataikhanov</i>		
CONTROLLERATE OF INSPECTION (ICV)	CONNECTOR RECEPTACLE	WEIGHT	SCALE
		SHT 1	SHTS 2

Формы: 10ПР1-9П135.000

Формы: 10ПР1-9П135.000

Формы	Знак	Поз	Обозначение	Наименование	Кол.	Примечание
*		12	10ПР1-9П135.009 ✓	Крышка COVER		*А4, А3 СТР. 30- шт., до- INTER- пук. 30М
*		3	10ПР1-9П135.012 ✓	Крышка COVER		*А4, А3 (1 PC) INTER- шт., до- СТАНБЕРК. ЗАМЕНА WITH NO. 12 NO. NO. 12
А3		7	10ПР1-9П135.013 ✓	Направляющая GUIDE STANDARD ITEMS Стандартные изделия	1	
		16		Штифт 3 Пр22а x 10 ОСТ 3-2234-80	4	Ц.9.кр.
		17		WASHER Шайба 3.65 Г. 019 ГОСТ 6402-70	1	
		13		SCREW Винт В1.М4-6е x 12.88.016 ГОСТ 17473-80	2	
		14		SCREW Винт В1.М3-6е x 8.88.016 ГОСТ 17473-80	2	
		15		SCREW Винт В1.М3-6е x 12.88.016 ГОСТ 17473-80	2	

10ПР1-9П135.000  
 1.83

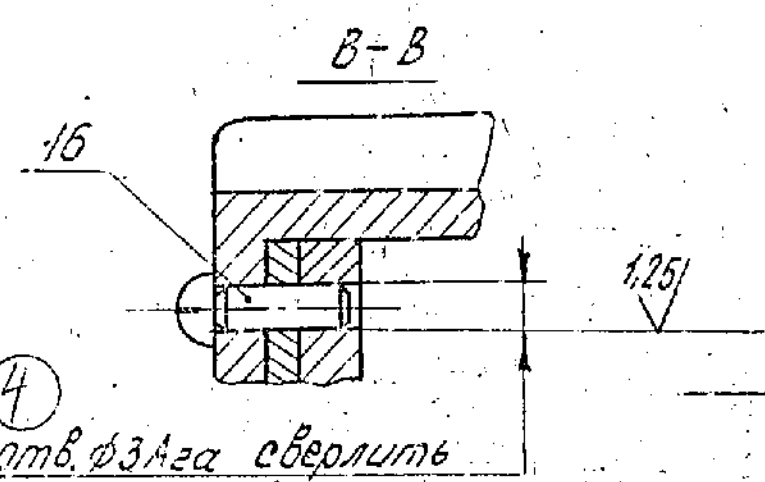
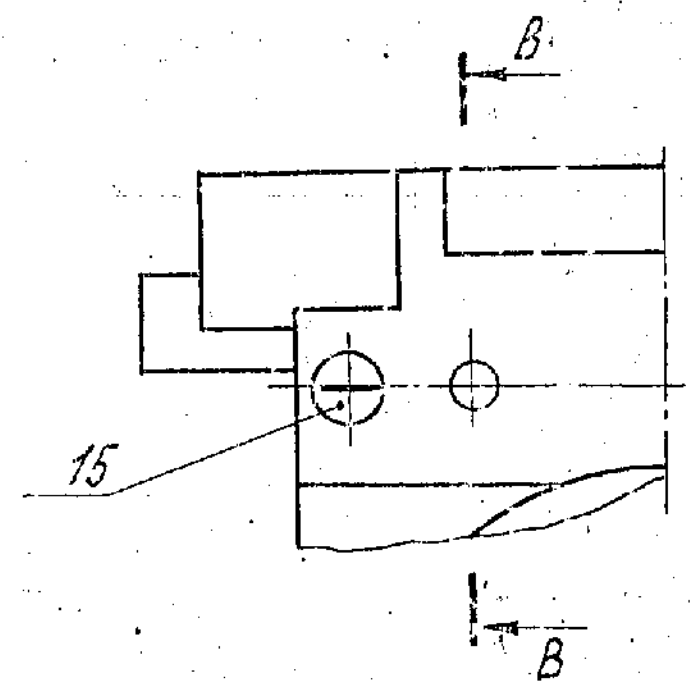
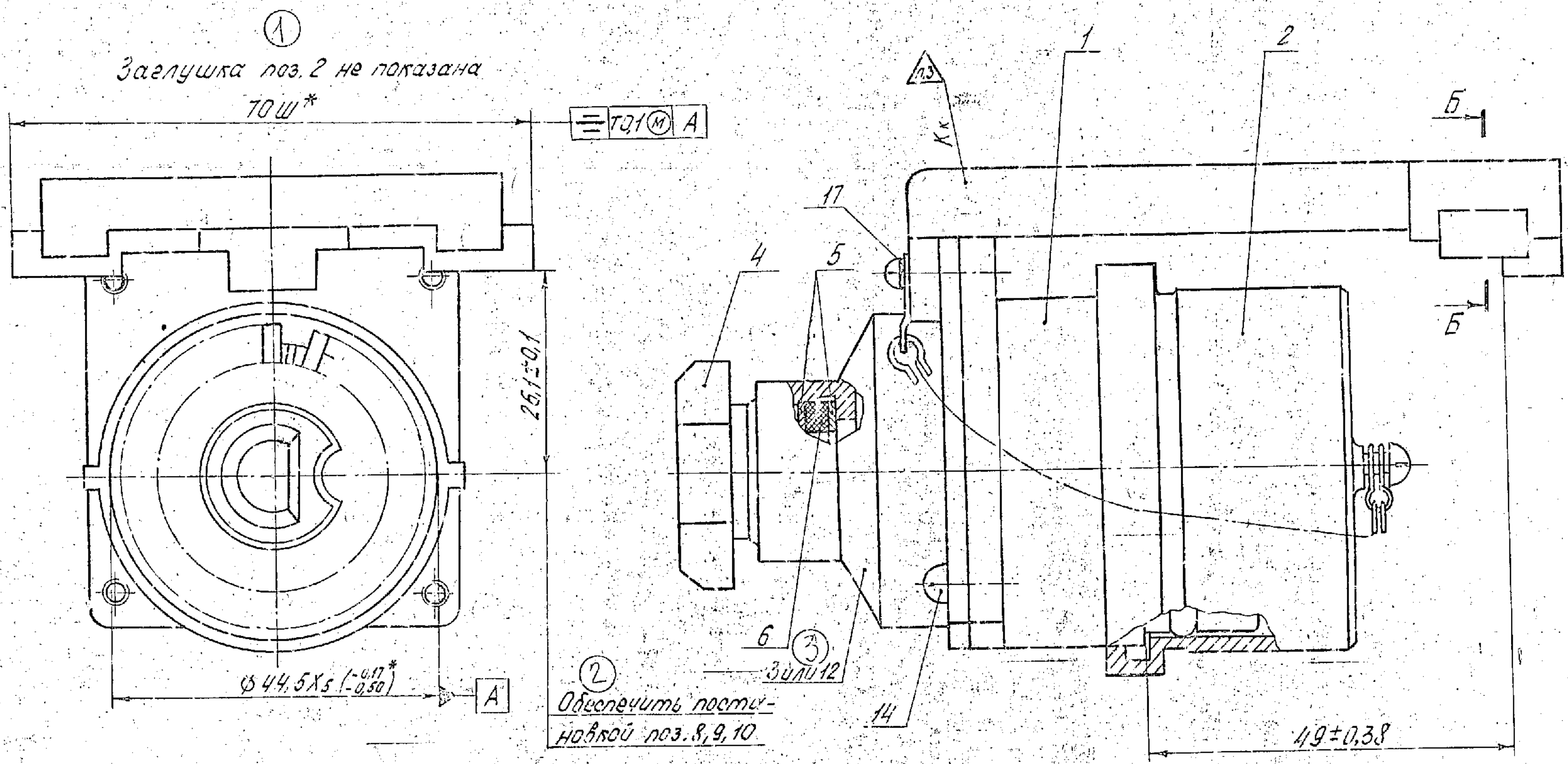
APPROVED	 M. YASU	10 ПР1-9П135.000	0 2177/59
CHECKED	 V. Belobranchev		
CONTROLLER RATE OF INSPECTION (ICV)	CONNECTOR RECEPTACLE	WEIGHT	SCALE
		SHT 2	SHTS 2

Копировать

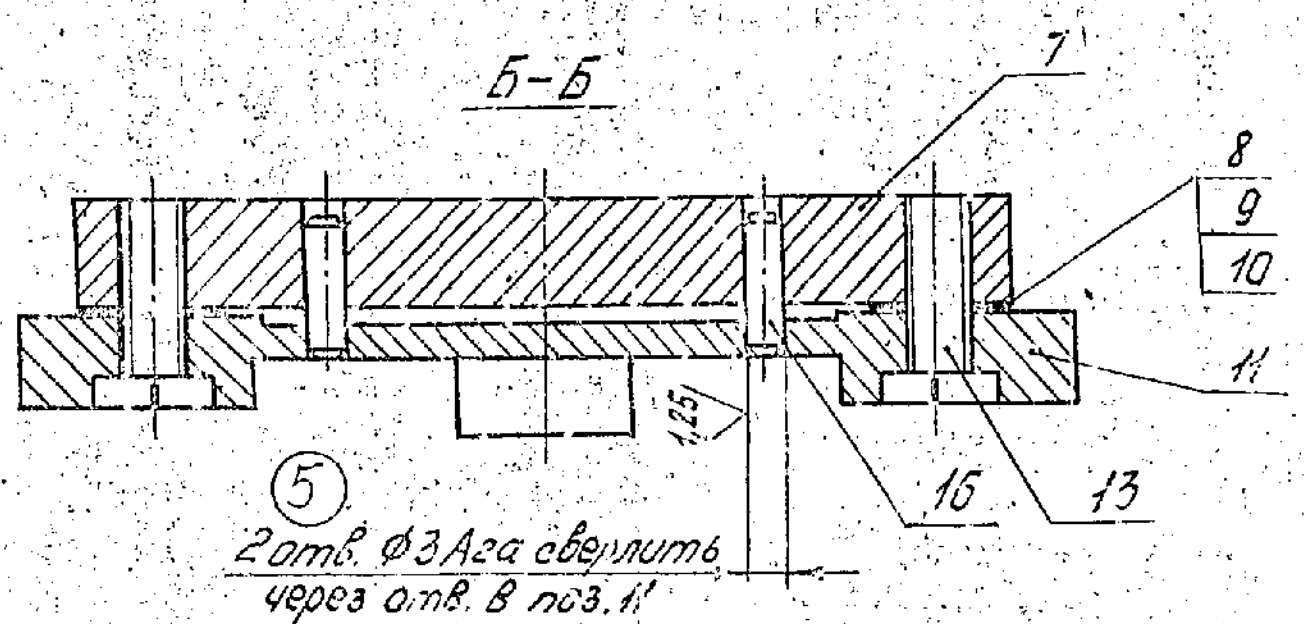
00PMDM



10 ПР1-9 П135-000 СБ  
А 1118-83



④ 2 отв. ф3Ага сверлить через отв. в поз.7



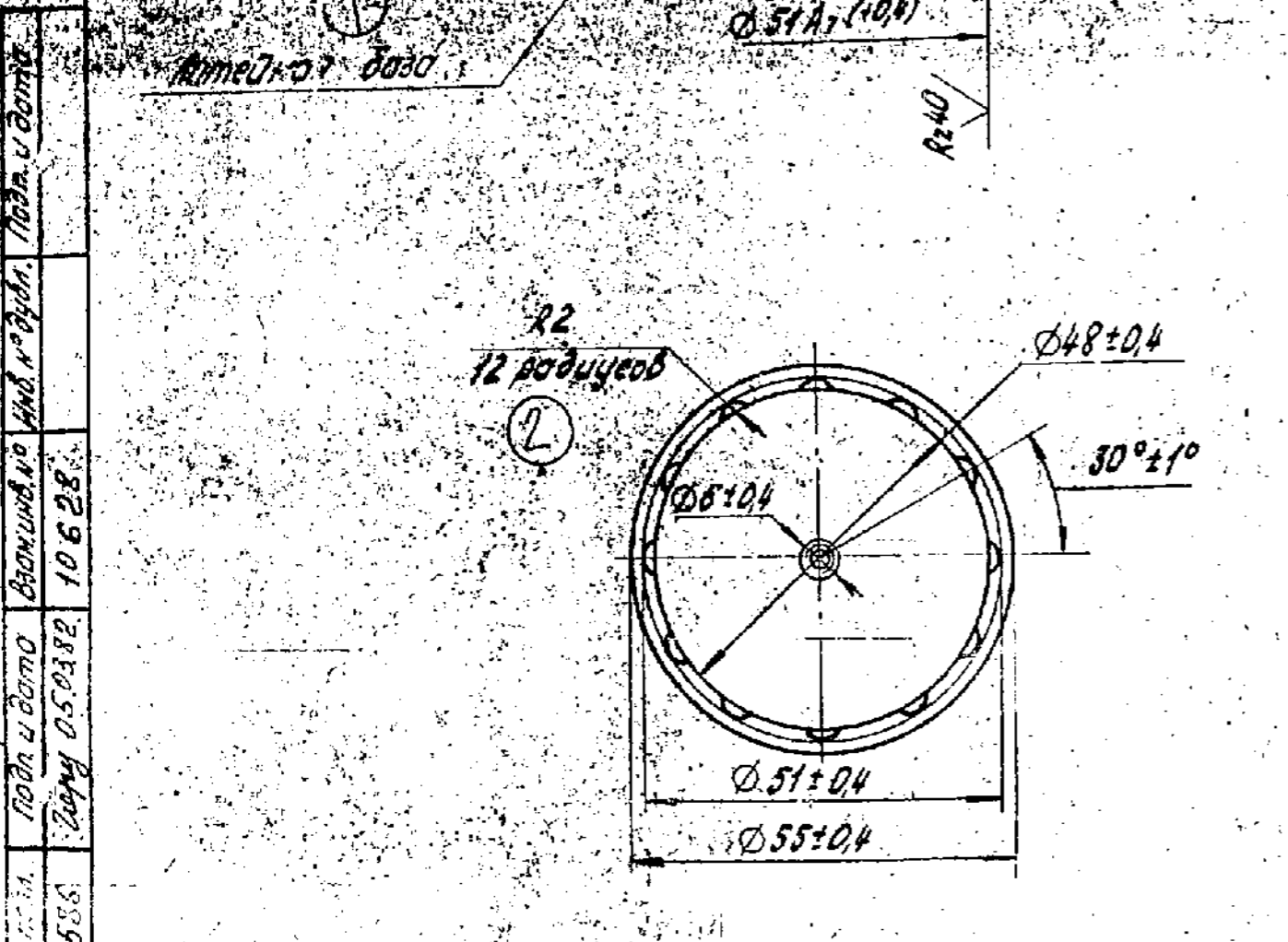
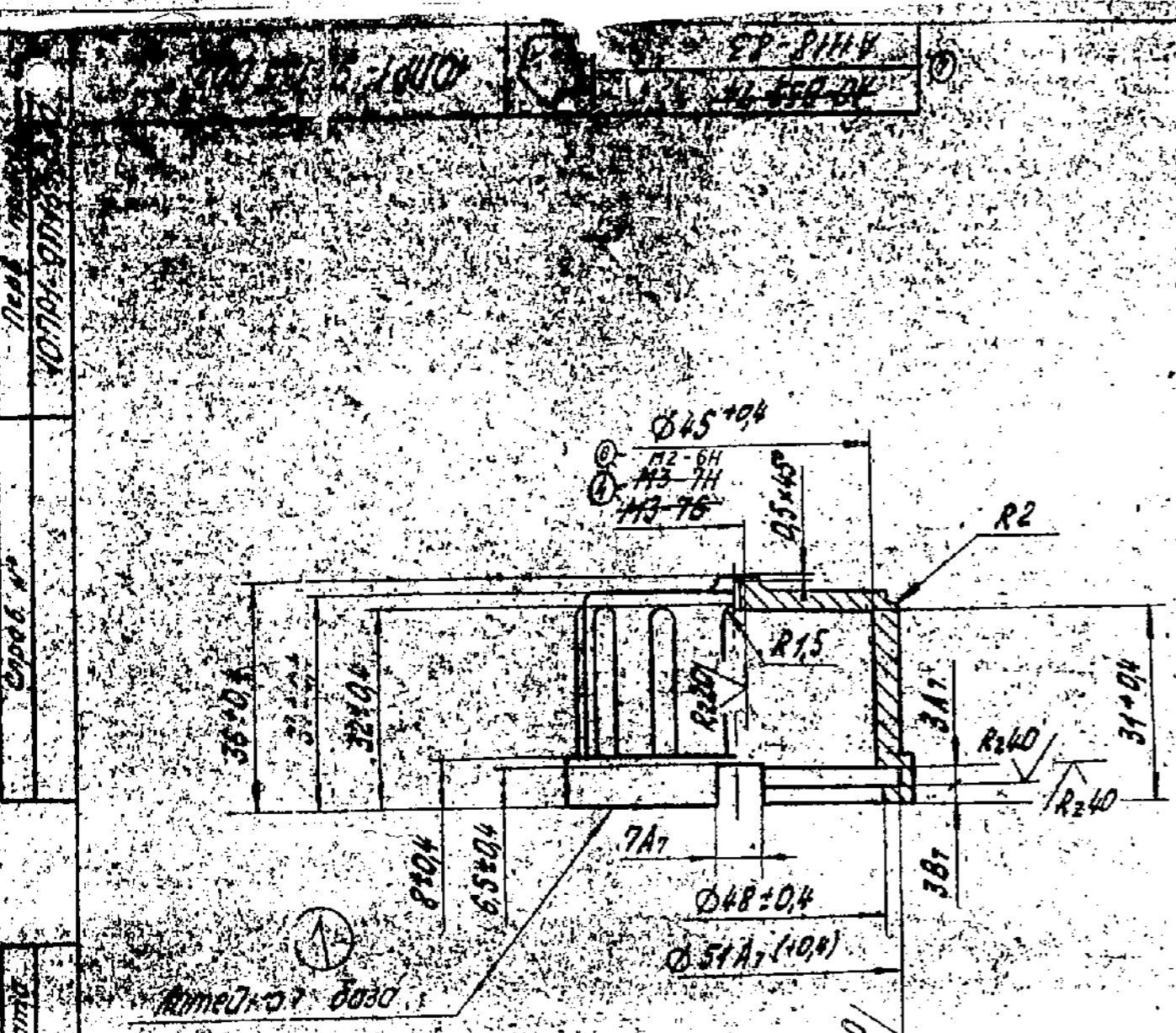
⑤ 2 отв. ф3Ага сверлить через отв. в поз.11

- ① Plug, Ref. No. 2, is not shown
- ② Ensured by the installation of parts, Ref. Nos 8, 9, 10
- ③ 3 or 12
- ④ 2 holes, dia. 3A<sub>2a</sub>, drill through hole in part, Ref. No. 7
- ⑤ 2 holes, dia. 3A<sub>2a</sub>, drill through hole in part, Ref. No. 11
- ⑥ 1. Dimensions marked with an asterisk (\*) are given for reference.  
2. Parts, Ref. Nos 7, 8, 9, 10, 11, 13, 14, 15, 16, 17 should be installed after laying the cable.  
3. Mark the stamp according to OCT 3-71-70.

- ⑥ 1.\* Размеры для справок.
- 2. Детали поз.7,8,9,10,11,13,14,15,16,17 ставить после монтажа кабеля.
- 3. Клеймить по OCT 3-71-70.

APPROVED	<i>M VASU</i>	10 ПР1-9 П135-000 СБ		0 2177/50
CHECKED	<i>[Signature]</i>	CONNECTOR RECEPTACLE ASSEMBLY DRAWING		WEIGHT SCALE 0-0554 2:1
CONTROLLERATE OF INSPECTION (ICV)		SHT		SHTS 1

18175  
 13.09.73  
 10 ПР1-9 П135-000 СБ  
 10 ПР1-9 П135-000 СБ  
 10 ПР1-9 П135-000 СБ



- ③
1. Литье под давлением.
  2. Заменитель материала отливка АЛ2-Д ОСТ 84-183-79 не более 10
  - ⑤ 3. Формовочные уклоны по ГОСТ 3212-80 в сторону увеличения размеров.
  4. Неуказанные литейные радиусы не более 1,5 мм
  5. Покрытие Ан.Окс. хром.
  6. Клеймить К по ОСТ 3-71-70 на бирке к партии
  7. Остальные требования по ОСТ 84-183-79 для отливки группы 2

- ① Casting datum surface
- ② 12 radii
- ③ 1. Casting under pressure.
2. Substitute material: casting АЛ2-Д ОСТ 84-183-79.
3. External drafts not to exceed 1°.
4. Unspecified casting radii are not more than 1.5 mm.
5. Coating: anodic oxidization, chromated.
6. Mark the stamp on the tag for the lot according to OСТ 3-71-70(K).
7. Other requirements are according to OСТ 84-183-79 for castings of group 2.

APPROVED	M VASU	10 ПР1-9 П135.002		D 2177/05	
CHECKED	<i>[Signature]</i>	PLUG		WEIGHT	SCALE
CONTROLLER OF INSPECTION (ICV)				10.5g	1:1
		CASTING 2-0АЛ20-Д, ОСТ 84-183-79		SHT	SHTS 1

Лист № 10 ПР1-9 П135.002  
Сред. № 10 ПР1-9 П135.002  
Подл. и дата  
Взам. инв. № 10628  
1588

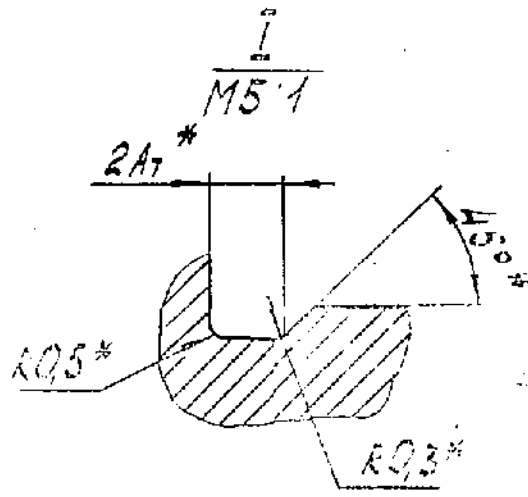
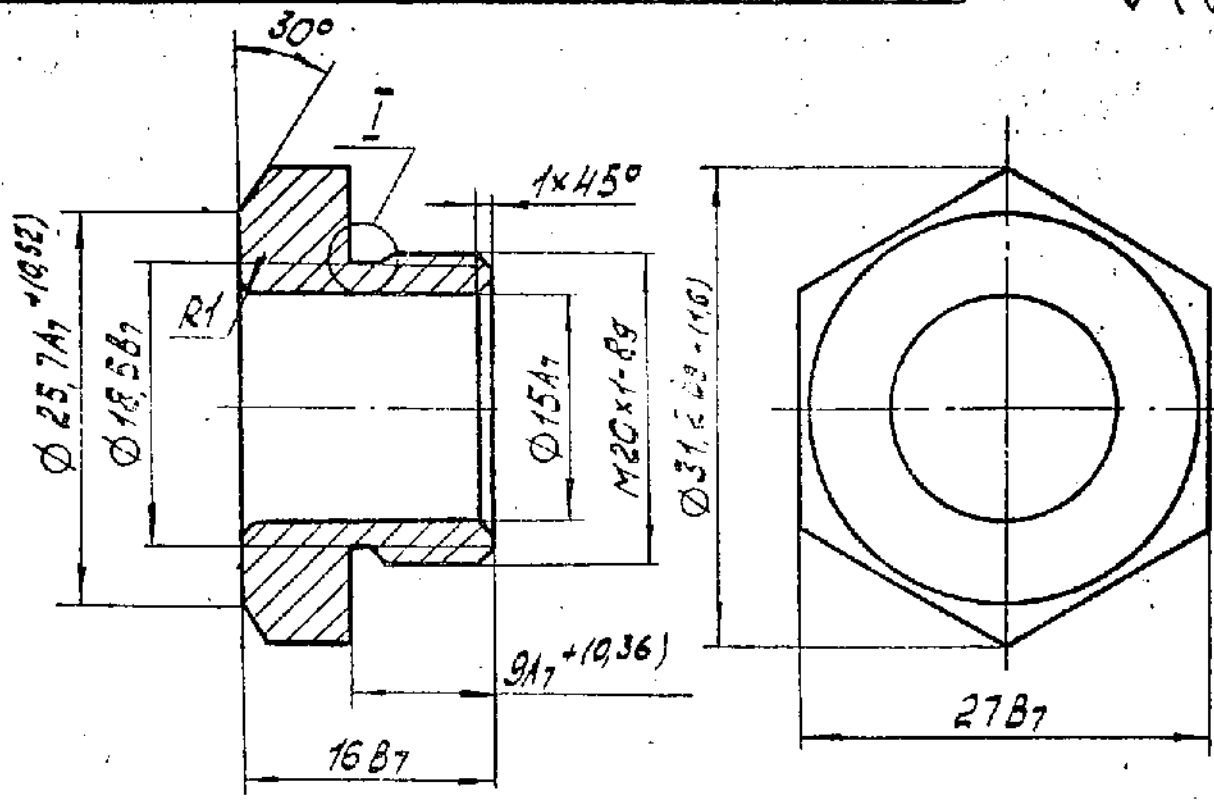


10ПР1-9П135.004



40655-74  
A118-83

③ R240 (✓)



1. Dimensions marked with an asterisk (\*) are ensured by tools.
2. Coating: anodic oxidization, chromated.
3. Mark the stamp on the tag for the lot according to OCT 3-71-70 (K).

Сделано 11.11.83

СНПР. № 10ПР1-9П135.004

APPROVED		10ПР1-9П135.004 66/0 2177	
CHECKED			
CONTROLLERATE OF INSPECTION (ICV)	NUT		WEIGHT SCALE
			0.003 2:1
	ALLOY 1ST, OCT 21488-76		SHT SHTS 1

КОНТРОЛЬНЫЕ ЧЕРТЕЖИ

ГОПРМОТ

10ПР1-9П135.005



10655-74  
1118-83

③

Rz80  
✓ (✓)

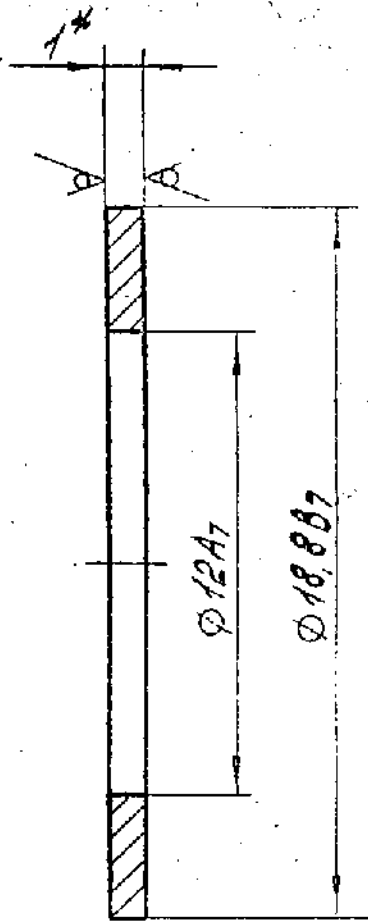
Верно: 10.03.83 г. 11.03.83 г. 29.03.83 г.

Проб. Пр. Имен  
10ПР1-9П135.000


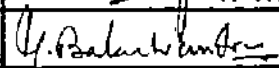
Сл. Пр. №

ВОССТАНОВЛЕН С ПОДЛИННИКА

См. Инв. № дубл. Подлинника



1. Dimension marked with an asterisk ( $\ast$ ) is given for reference.
2. Coating: Kt9 - cadmium plating.
3. Mark the tag for the lot according to OCT 3-71-70 (K).

APPROVED	 M VASU	10ПР1-9П135.005 <sup>67/0 2177</sup>	
CHECKED			
CONTROLLERATE OF INSPECTION (ICV)	WASHER		WEIGHT SCALE
			0.001 5:1
			SHT SHTS 1
SHEET		10 OCT 16922-70	

11.03.83

10ПР1-9П135.006

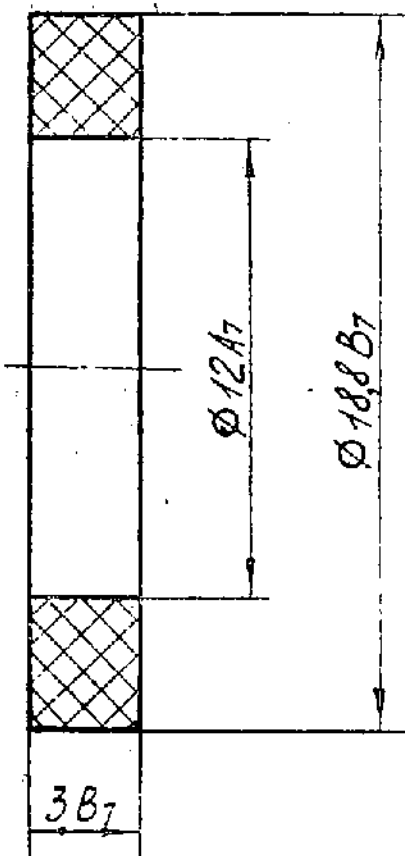


A118-83

Верно: № 10ПР1-9П135.000  
Перв. примек.

Спроб. №

Возстановлен с подписника  
Взостановлен с подписника  
Взостановлен с подписника  
Взостановлен с подписника



1. Roughness of moulding surfaces of the press mould is  $\sqrt{0.63}$ .
2. Dimensions are ensured by tools.
3. Mark the stamp on the tag for the lot according to OCT 3-71-70 (K).
4. Other technical requirements are according to TV 38.10554-76.

APPROVED	<i>[Signature]</i> M VASU	10ПР1-9П135-006	D 2177/60		
CHECKED	<i>[Signature]</i>				
CONTROL RATE OF INSPECTION [Signature]		GASKET		WEIGHT	SCALE
				1.5g	5:1
				SHT	SHTS 1
		RUBBER STOCK W/ [Signature] TY 38.005.1166-75			









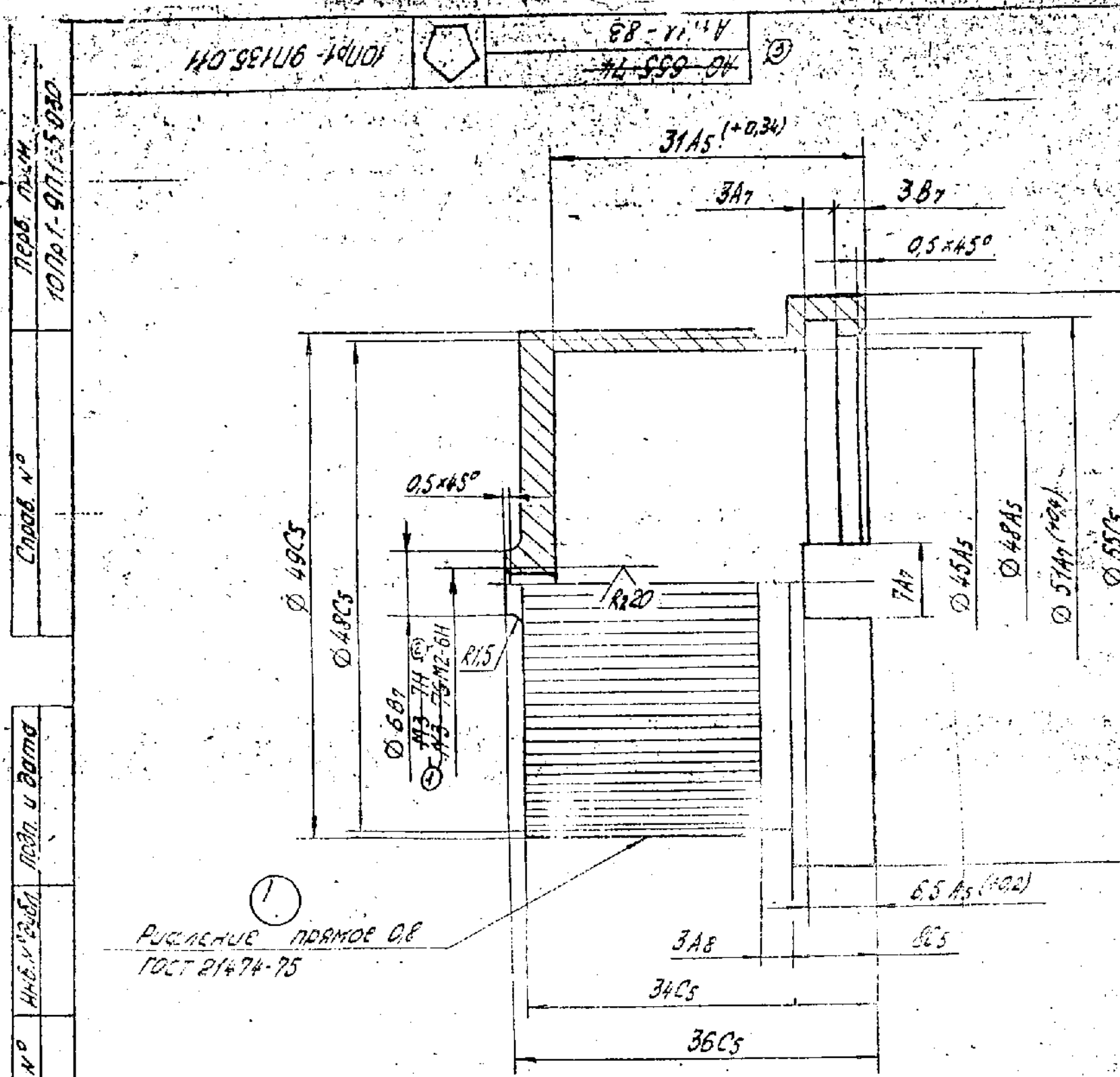


600 99113-10104

1. Dimensions marked with an asterisk (\*) are ensured by tools.
2. Coating: anodic oxidization, chromated.
3. Mark the appropriate stamp on the tag for the lot according to OCT 3-71-70 (K).

304 L80 N°	1000 0000
12.11	

APPROVED	<i>[Signature]</i>	10 ПР1-9 П135.009	0 2177,71
CHECKED	<i>[Signature]</i>	COVER	WEIGHT SCALE
CONTROLLERATE OF INSPECTION (ICV)			SHT 2



- (1) Straight grooving 0.8, ГОСТ 21474-75
- (2) 1. Coating: anodic oxidization, chromated.
- 2. Mark the appropriate stamp on the tag for the lot according to OCT 3-71-70 (K).

②  
 1. Покрывать Ан. Окс. хр.  
 2. Карюнуть К по OCT 3-71-70 на бурке к партии.

№ документа	10ПР1-9П135.011
Исполнитель	М.В.С.
Проверен	
Согласован	
Утвержден	
Дата	
Исполнитель	
Проверен	
Согласован	
Утвержден	
Дата	

APPROVED	<i>M. VASU</i>	10ПР1-9П135.011	0 2177/1..
CHECKED	<i>[Signature]</i>		
CONTROLLERATE OF INSPECTION (ICVI)	PLUG	WEIGHT	SCALE
		10g	2:1
		SHT	SHTS 1
		BAR II 16T, ГОСТ 21462-76	

10ПР1-9П135-012  
 40-555-74  
 40-555-74  
 40ПР1-9П135-012

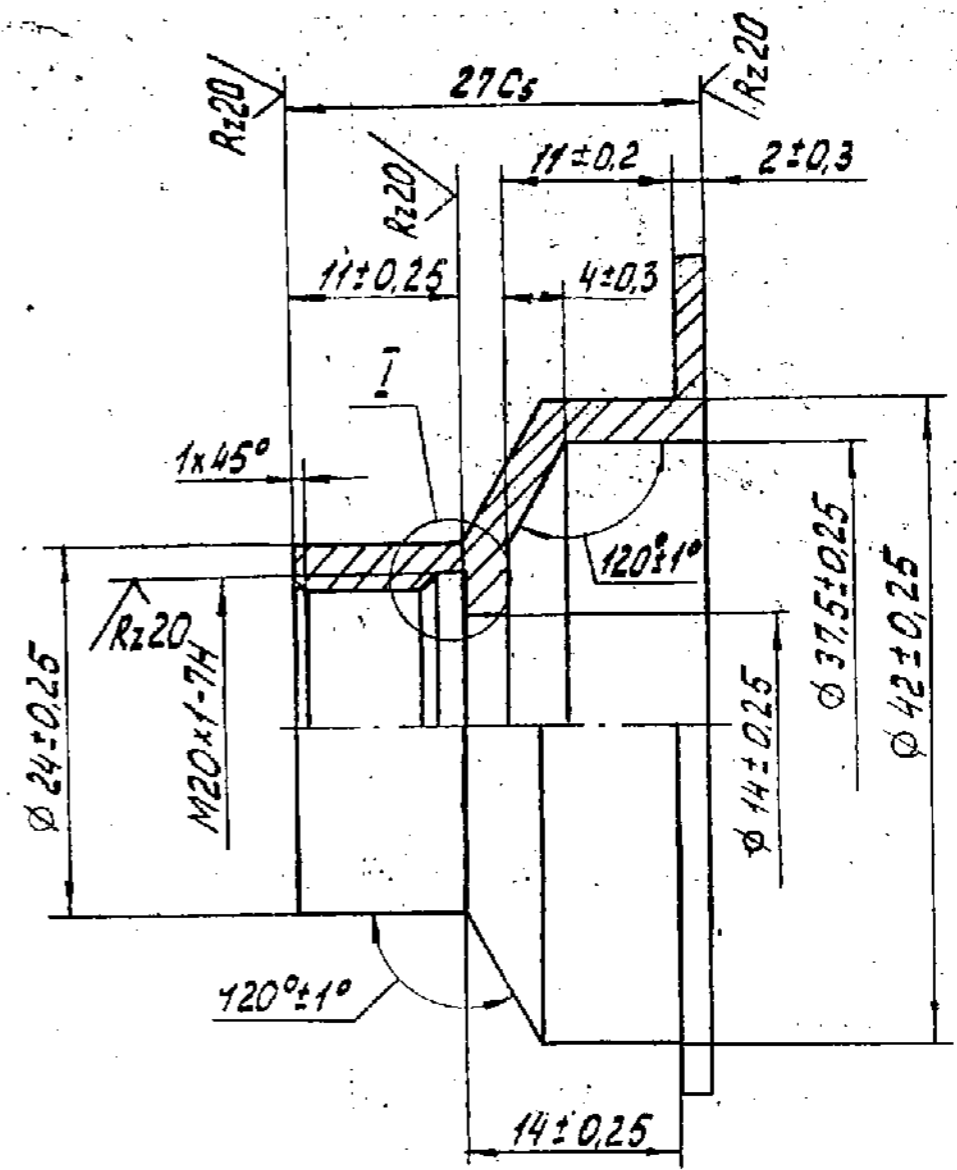
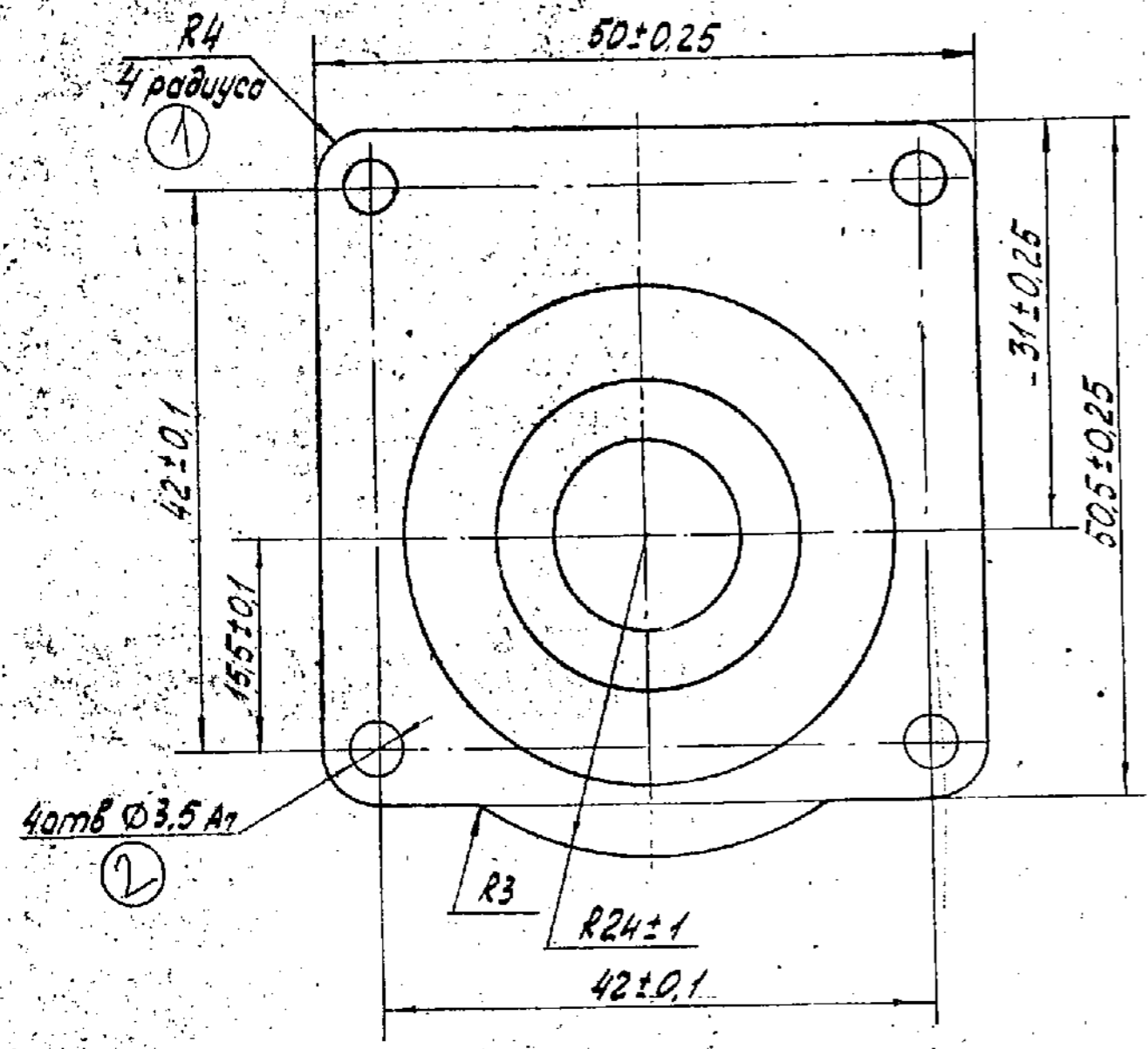
40-555-74  
 40-555-74  
 40-555-74

- (1) 4 radii
- (2) 4 holes
- (3) For technical requirements, refer to the next sheet.

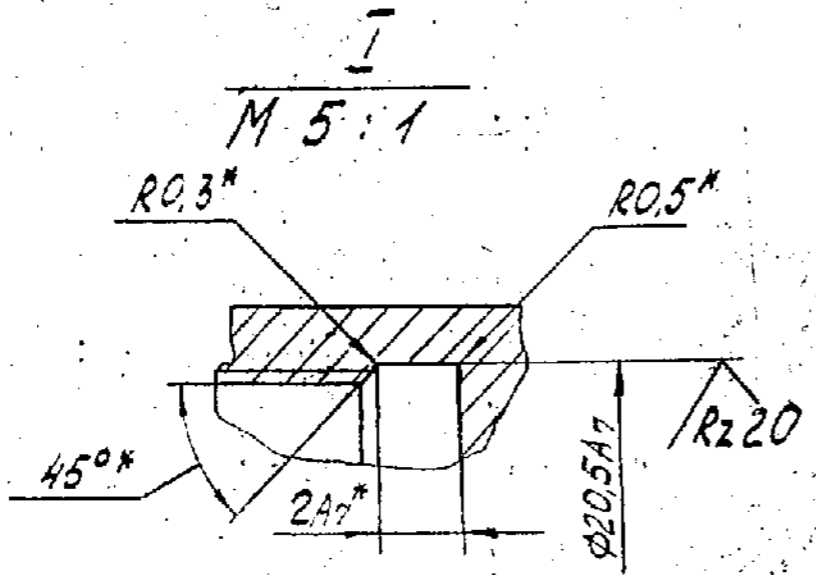
Rz 40  
 (✓) (✓)

Склад №  
 107701-9П135-000

Исполн. Власов 24.10.83  
 Проверил Власов 24.10.83  
 Проверил Власов 24.10.83  
 Проверил Власов 24.10.83



3  
 ТТ на листе 2



APPROVED	<i>H VASU</i>	10ПР1-9П135-012	0 2177/73
CHECKED	<i>H. Beland...</i>	COVER	
CONTROLLERATE OF INSPECTION (IC VI)		WEIGHT	SCALE
		8.5g	2:1
		SHT 1	SHTS 2
		АЛЛОУ ОАЛ20. ОСТ 884-183-79	

